

Date: Wednesday, 28/01/2009 5:00:06 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : HANDLE RIM
 Job Number : 45330
 Estimate Number : 11334
 P.O. Number :
 This Issue : 28/01/2009 S.O. No. :
 Prsht Rev. : NC Part Number : D333019
 First Issue : / / Type : MACHINED PARTS Drawing Number : D3330 REV D
 Previous Run : 45277 Project Number : N/A
 Material :
 Due Date : 10/02/2009 Qty: 6 Um: Each
 Written By :
 Checked & Approved By : JUD 09.01.29
 Comment : Est: A 05.01.13 New issue KJ/JLM
 est B 07.05.14 rev C dwg EC
 Est C 07.12.12 Rev D dwg EC verified by:DD

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M1018TR13125W109

ROUND TUBING 1.3125 x .109w



Comment: Qty.: 0.0525 f(s)/Unit Total: 0.3150 f(s)
 1010-1025 Steel Bar
 Material: AISI 1010-1025 1" Schedule 80 B tubing
 (M1025TRS80)
 Identify for D3330-19
 Batch: M16 889

UP 09/01/30

(6 pcs)

2.0

HARDINGE

HARDINGE CNC LATHE SMALL



Comment: HARDINGE CNC LATHE SMALL
 Turn as per Folio FA491 and Dwg D3330
 Deburr

UP 09/01/30

(6 pcs)

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

UP 09/01/30

(6 pcs)

4.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.T. 09/01/30

(6)

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
 Location: Carl

9/12/12

(64)

UP

Date: Wednesday, 28/01/2009 5:00:06 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HANDLE RIM

Job Number: 45330

Part Number: D333019

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



09/02/03 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

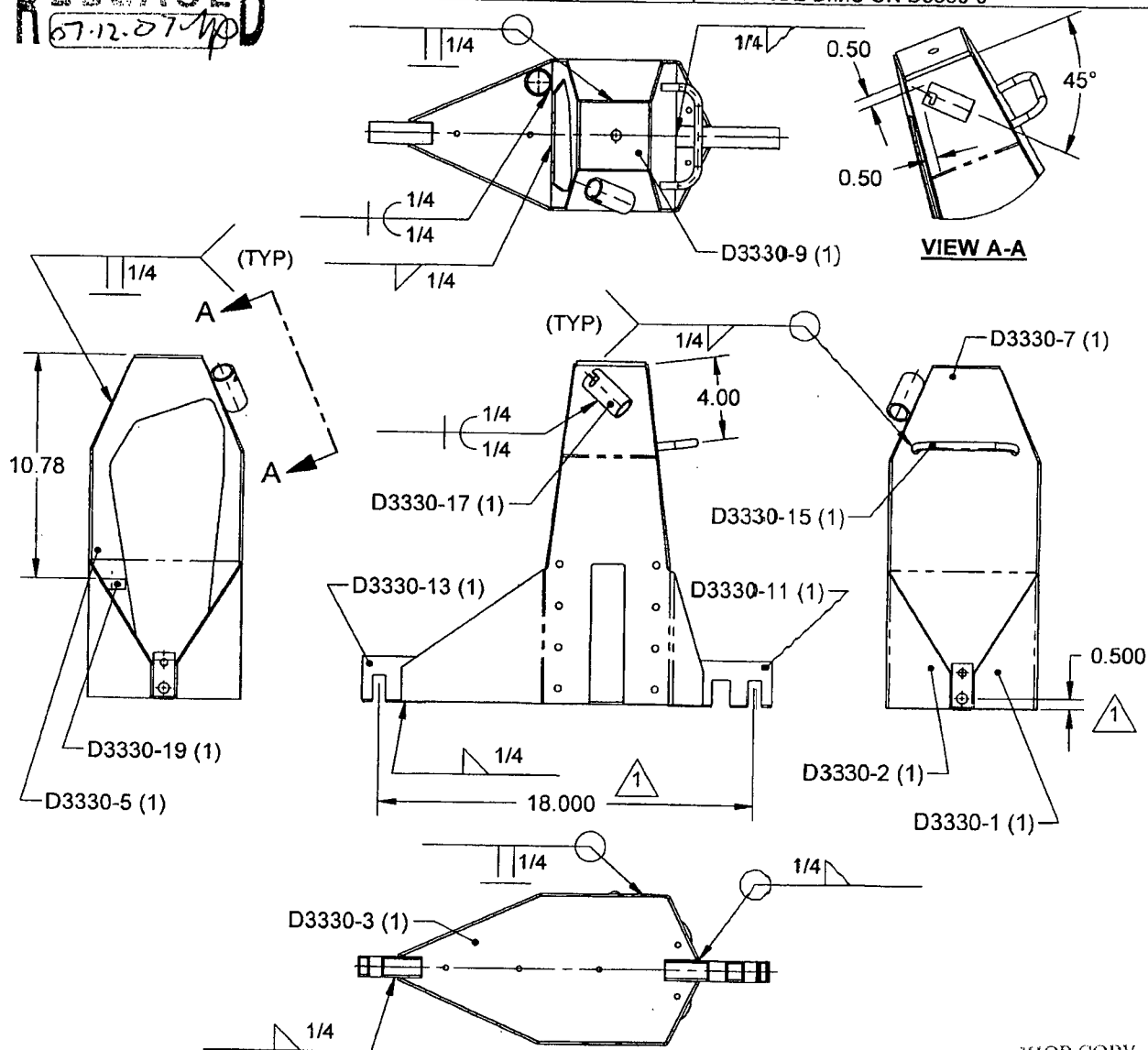


MF- 69-02-02



DESIGN 13	DRAWN BY DC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 13	APPROVED MP	DRAWING NO. D3330	REV. D SHEET 1 OF 9
DATE 07.12.06		TITLE FRAME WELDMENT	SCALE 1:8
REV	DATE	DESCRIPTION	
A	04.12.16	NEW ISSUE	
B	05.02.26	RE-DESIGN	
C	07.03.20	ADD 0.100 DIM; RAISED BEND OF -1/2 BY 0.125	
D	07.12.06	CHANGE DIMS ON D3330-9	

RELEASED
07.12.07 MP



D3330-041 FRAME WELDMENT

NOTES:

- 1) POSITION PARTS AS PER JIG D3330-041T1
- 2) WELD PER QSI 004
- 3) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.010 TO 0.020

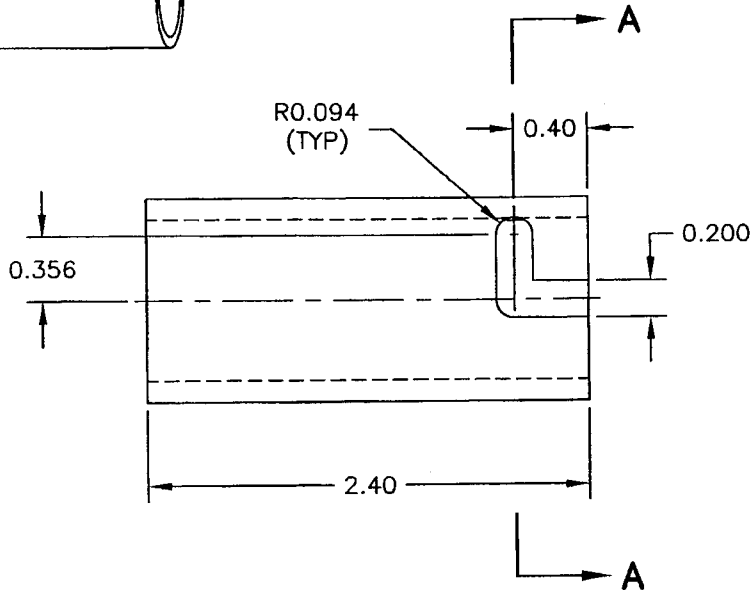
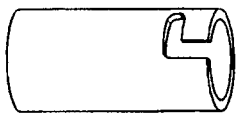
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. **45330**

COPYRIGHT © 2004 BY DART AEROSPACE LTD

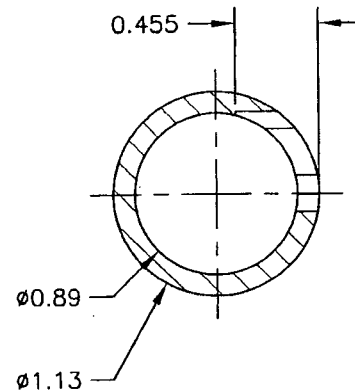
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



DESIGN <i>JB</i>	DRAWN BY <i>DC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>JB</i>	APPROVED <i>MP</i>	DRAWING NO. D3330	REV. D SHEET 8 OF 9
DATE 07.12.06		TITLE FRAME WELDMENT	SCALE 1:1

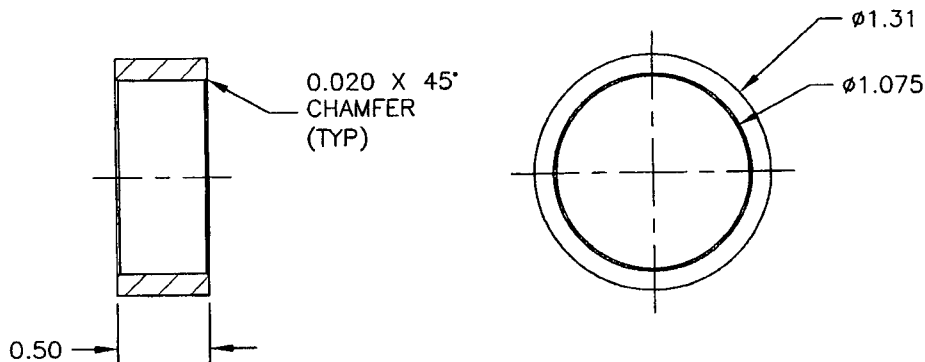


RELEASED
07.12.07 *W/A*



SECTION A-A

D3330-17 HANDLE SOCKET



D3330-19 HANDLE RIM

NOTES:

- 1) MATERIAL: 1010-1025 ROUND BAR STEEL PER MILL-S-7097 (REF. DART SPEC. M1025TR)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *15330*

Copyright © 2004 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.